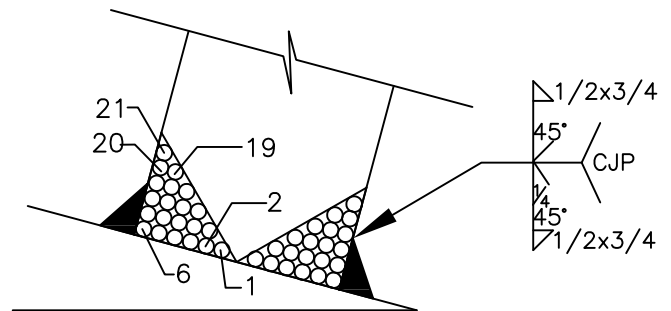


GENERAL NOTES CONTINUED

PADEYE FABRICATION

1. THE CUTTING OF SURFACES TO RECEIVE WELDS SHALL BE BY O/A CUTTING AND THEN CLEANED BY GRINDING SMOOTH. PREHEAT PRIOR TO CUTTING.
2. FOR THICKNESS $2\frac{1}{2}$ " OR GREATER PROVIDE PREHEAT AND INTERPASS TEMPERATURES OF MIN 300°F.
3. WELDING PASS NUMBER SHOWN DIAGRAMMATICALLY TO INDICATE WELDING SEQUENCE OF PASSES AND LAYERS. THE INDICATED NUMBER OF PASSES IS BASED ON $\frac{1}{4}$ " WIDE DEPOSITS.
4. USE DUCTILE, LOW HYDROGEN ELECTRODES – E7018 FOR SMAW PROCESS. ENGINEER APPROVED WRITTEN WELDING PROCEDURES REQUIRED PRIOR TO WELDING.
5. USE STRINGER PASSES ONLY (NO WEAVING).
6. WELD PASSES LAID IN LAYERS AS SHOWN AND EACH PASS TO MELT AT LEAST $\frac{1}{3}$ OF PRECEDING PASS TO ENSURE THOROUGH FUSION BETWEEN PASSES.
7. IMMEDIATELY AFTER SLAGGING, LIGHTLY PEEN EACH PASS, EXCEPT FIRST AND LAST PASSES; PEENING IS ACCOMPLISHED WITH THE POWER SLAGGING GUN USING A BLUNT-NOSED CHISEL TOOL. FOUR OR FIVE LIGHT RATTLING PASSES.
8. THE REINFORCEMENT FILLET WELDS ($\frac{1}{2}$ " x $\frac{3}{4}$ ") ALONG EACH SIDE ARE NEEDED TO MINIMIZE STRESS CONCENTRATION.
9. PROVIDE MAGNETIC PARTICLE INSPECTION OF EACH WELD LAYER.
10. PROVIDE POST WELD HEAT OF 300°F AND THEN WRAP ENTIRE JOINT IN INSULATING BLANKETS TO SLOW THE RATE OF COOLING.
11. PROVIDE ULTRASONIC TESTING UPON COMPLETION OF THE WELDED JOINT WHEN JOINT HAS COOLED.
12. PROVIDE CHARPY V-NOTCH (CVN) TESTING NEAR THE CENTER OF THE WELDED JOINT. RESULTS SHALL INDICATE A MIN ABSORBED ENERGY OF 24 FT-LB AT 70°F.
13. RECOMMEND MECHANICAL STRESS RELIEF THROUGH VIBRATION (VIBRATORY STRESS RELIEF). THIS WILL ENHANCE FATIGUE LIFE. THE THOMPSON SCAN METHOD HAS BEEN EFFECTIVE IN THIS REGARD.

NOT TO SCALE, WELD WASHERS OMITTED FOR CLARITY



NOTE: PEEN PASSES
2 THROUGH 2D
INCLUSIVE

LOADING AND LIFTING CRITERIA

1. LIFTING SLINGS ARE TO BE 40 FT EACH.
2. WITH 2 INCH HIGH STENCILED LETTERS MARK THE WLL OF EACH PADEYE AND THE WLL OF THE PLATFORM.
3. AFTER FABRICATION ENTIRE ASSEMBLY WEIGHT SHALL BE STENCILED ON PLATFORM IN 4" LETTERS.
4. WLL SHALL NOT EXCEED 150,000LBS.
5. ADDITIONAL STACKED WEIGHTS SHALL BE UNIFORMLY DISTRIBUTED ON PLATFORM.
6. WHEN LIFTING BOTH TEST WEIGHTS TOGETHER, PADEYE FOR LINKING BOTH TEST WEIGHTS IS TO BE USED WITH A 6.5 METRIC TON ANCHOR SHACKLE.